

Date: Monday, 12/05/2008 9:58:07 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: 206 EXTRUSION BENDING		
Job Number	: 39178			Part Number	: D2620		
Estimate Number	: 10311			Drawing Number	: D2620 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 12/05/2008 S.O. No. :			Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SKIDTUBES			Due Date	: 25/05/2008 Qty: 20 Um: Each		
Previous Run	: 39154						
Written By	:						
Checked & Approved By	: JUL 08-S-12						
Comment	: Est. D 02.07.26 Change Dwg to rev.B; Updated Location RF						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D26001160	Extrusion Round 3" 206	
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Extrusion Round 3" 206 Pick: Qty Part Number Description Batch 1 D2600-1 Extrusion Round 3"206 <i>34715/24508</i> <i>*9</i> <i>*11</i>			
2.0	SKIDTUBES 1	SKIDTUBES RESOURCE 1	
<b>Comment:</b> LANDING GEAR RESOURCE 1 1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A and Folio Ft008 2- Cut Fwd end of tube as per Dwg D2620 <i>AWM / 20</i> <i>08/05/13 (x20)</i>			
3.0	QC5	INSPECT WORK TO CURRENT STEP	
<b>Comment:</b> INSPECT WORK TO CURRENT STEP <i>08/05/13 (x20)</i>			
4.0	PACKAGING 1	PACKAGING RESOURCE #1	
<b>Comment:</b> PACKAGING RESOURCE #1 Identify and Stock Location: <i>skid tube cell</i> <i>BT 08-09-17 (x20)</i>			
5.0	QC21	FINAL INSPECTION/W/O RELEASE	
<b>Comment:</b> FINAL INSPECTION/W/O RELEASE <i>08/05/14 (x20)</i>			
Job Completion <i>8-05-13</i>			

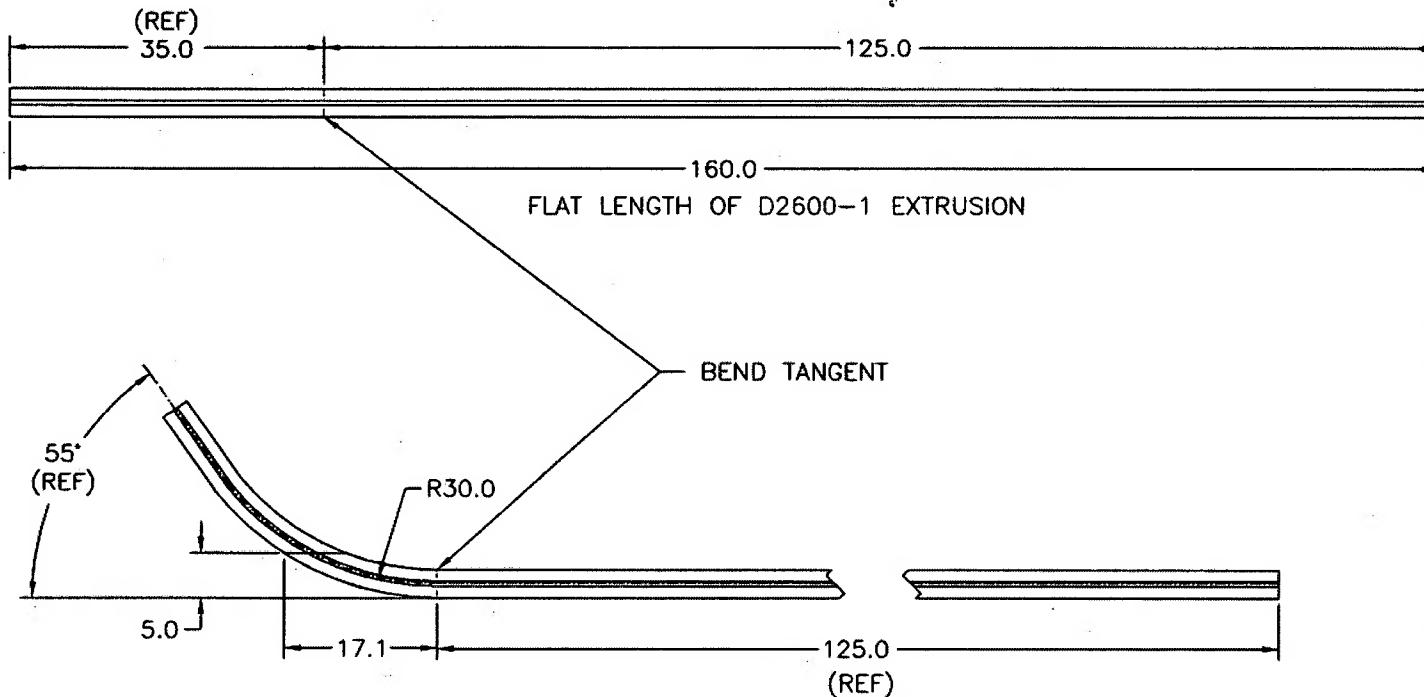
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING  
206 SKIDTUBE BENDING



DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE.  
NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE.  
DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE  $3.20 \pm 0.20$  IN THE BEND.  
TUBE WIDTH SHOULD BE  $3.200 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE.  
TUBE HEIGHT SHOULD BE  $3.15 \pm 0.20$  IN THE BEND.  
TUBE HEIGHT SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

**DART**

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DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
	RF	FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED	APPROVED	REV. B
	KE	D2620
DATE		SHEET 1 OF 1
99.09.10		
A	97.11.07	NEW ISSUE
B	97.09.10	UPDATE FOR IN-HOUSE BENDING
		SCALE
		1:20

**RELEASED**  
44.04.15 DS